

# Work Order ID 79797

**\*79797\***

Page 1

February-03-12 10:24:26 AM

Item ID: D3199-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket  
 Start Date: 03/02/2012 Start Qty: 36.00 **\*36\*** Cust Item ID:  
 Required Date: 17/02/2012 Req'd Qty: 36.00 **\*36\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 12/02/03 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3199	E

100	FLOW WATER JET	0.00							
<b>*100*</b>									
Waterjet	<b>Memo</b>	0.00							
FLOW CNC Waterjet	Cut as per Dwg D3199								
304-040	Dwg Rev: <u>E</u>								
	Prog Rev: <u>E</u>								
	Deburr if required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									

12-2-18

12-2-18

*[Handwritten signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				W	12	02-21	(48)
130 <b>*130*</b> Small Fab Small Fab Small Fab	Small Fab  Memo Form as per dwg D3199 use DT9723	0.00  0.00		SB 12/02/21		(45)			
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				W	12	02-21	(45)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**\*79797\***

February-03-12 10:24:26 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*36\***

\*36\*

**Reference:**

Run Start \*NR1\*

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

150

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00

**\*150\***

### Powdercoat

## Powder Coating

## Memo

START TIME: 2h00  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 2h30

0.00

4.5x

~~8~~

28/12/02/27

160

### QC3- Inspect Part Finish

0.00

**\*160\***

QC

## Quality Control

## Memo


0.00

45,  
rouv

6

del 17/02/28

170

Identify as per dwg & Stock Location  0.00

0.00

**\*170\***

## Packaging

## Packaging

## Memo

0.00

45x

SP 12-02-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 79797****\*79797\***

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

MLJ 12/02/29  
ME  
12-02-29

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



# Picklist Print

February-03-12 10:24:30 AM

Page 1

Work Order ID: 79797

**\*79797\***

Parent Item: D3199-1

**\*D3199-1\***

Parent Item Name: Bracket

Start Date: 03/02/2012

Required Date: 17/02/2012

Start Qty: 36.00

Required Qty: 36.00

Comments: IPP Rev:C Removed Scribing 05-11-05 JLM  
 IPP Rev:D As per Rev B 06-11-24 JLM IPP Rev:E  
 11.03.31 as per ecn 11-531 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

131.5165

0.099

3.751579

5

**\*M304S20GA\***

**\*\***

1812-2-18

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

131.5165

116623

0.2

117933

27.3442

118400

25.6723

118964

36.5

119346

41.8

119346

48

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

A

D

C

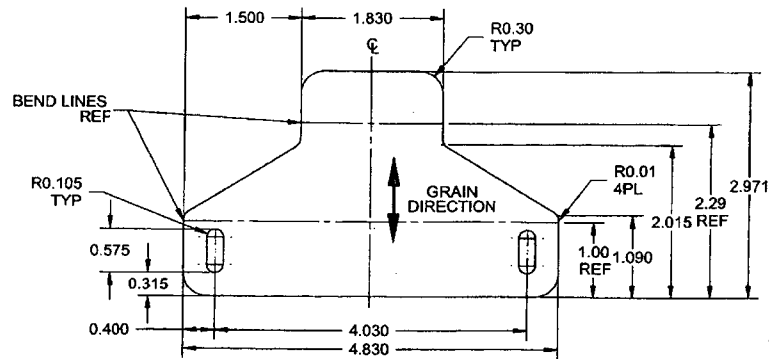
B

A

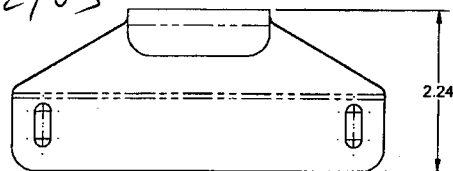
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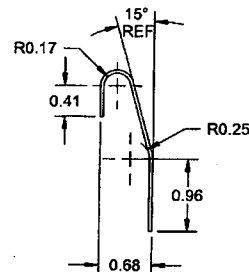
79797 M.C.J  
12/02/03



**D3199-1F FLAT PATTERN**



**D3199-1 BRACKET**  
MADE FROM D3199-1F



**RELEASED**  
2011-07-18

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/-4 = 0.26 lbs EACH

E	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO OPTIMIZE FIT.	MB	11.07.11
D	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF: PART11-78	MB	11.03.21
C	ADD -3/-4 PART (SHEET 2-4)	HS	08.11.18
B	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	CB	08.11.01
A	NEW ISSUE	CP	03.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.11		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3199</b>	REV. E
TITLE <b>BRACKET</b>	SHEET 1 OF 4
	SCALE NTS

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8 7 6 5 4 3 2 1

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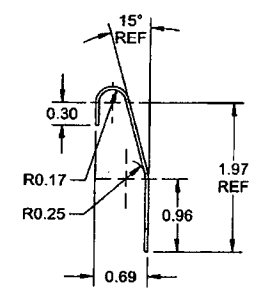
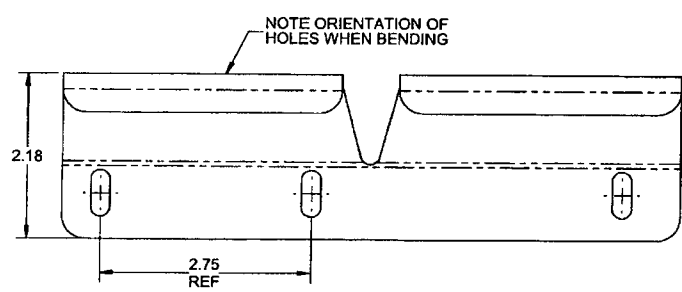
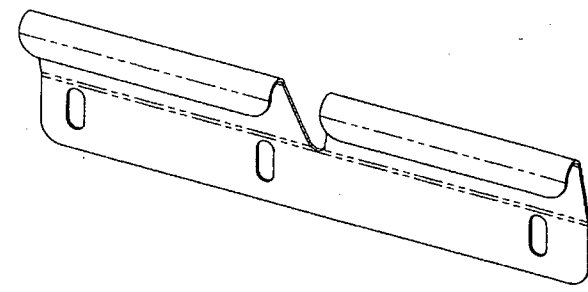
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

7997



**D3199-3 BRACKET**  
MADE FROM D3199-3F

RELEASED  
2011-07-18

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3199	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.07.11	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

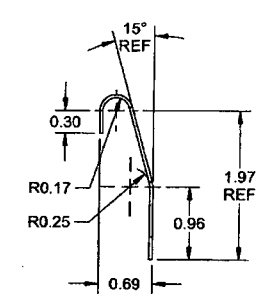
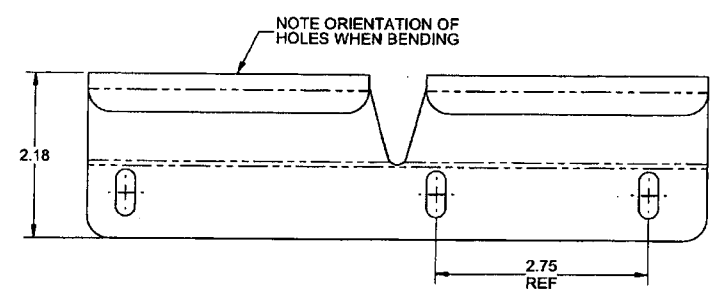
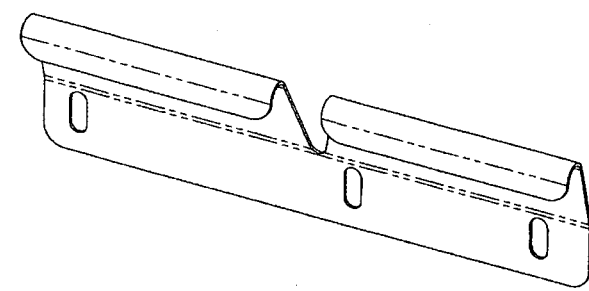
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**NOTE:** Date & initial all entries



79797



**D3199-4 BRACKET**  
MADE FROM D3199-3F

RELEASED  
2011-07-18  
JMS

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3199	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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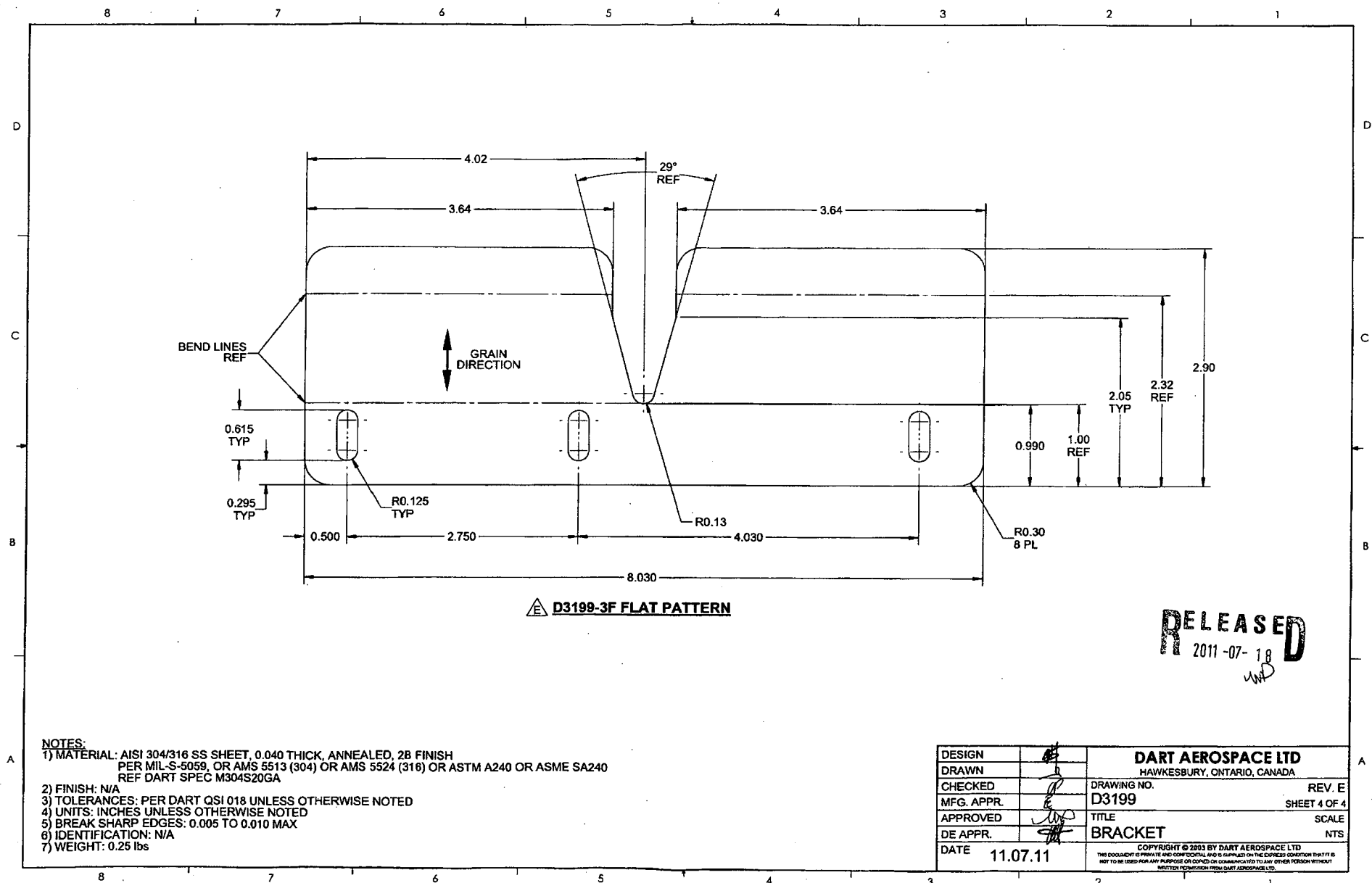
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